



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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644.4101

Job Sheet 181912



Part No: 644.4101

Job Qty: 15 ea

Part Name: Pivot Step Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/13/18

Job Tracking No:

Due Date: 9/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 644.4100 Rev F2 IPP Rev B 18.04.04 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	15 Ea		9/28/18	0.00	0.00	Start Up Small Fab-4		OCT 23 2018
110	Small Fab	15 pcs		9/28/18	0.00	15.00	Small Fab-8		OCT 24 2018
120	QC	15 pcs		9/28/18	0.00	0.00	QC5		OCT 24 2018
130	Packaging	15 pcs		9/28/18	0.00	0.00	Packaging3		OCT 24 2018
140	QC21-FG	15 Ea		9/28/18	0.00	0.00	QC21		21

Part Op 110 - ASSEMBLE BRACKETS AS PER DWG
Descriptions:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
644.4103	Aft Bracket Assembly	15 Ea (1 ea)	100-Start up Operation	5113026
644.4110	Aft Bracket, Large	15 Ea (1 ea)	100-Start up Operation	5116980
644.4112	Spacer	30 Ea (2 ea)	100-Start up Operation	5113173
644.4113	Spacer, Stop	30 Ea (2 ea)	100-Start up Operation	5113172
644.4118	Washer, Nylon	30 Ea (2 ea)	100-Start up Operation	5104138
644.4120	Spacer, Crosstube	15 Ea (1 ea)	100-Start up Operation	5113032
AN310-4	Nut	15 Ea (1 ea)	100-Start up Operation	5060062-1810
AN4-45	Bolt	15 Ea (1 ea)	100-Start up Operation	5060053
AN4-47A	Bolt	15 Ea (1 ea)	100-Start up Operation	5062282
AN5-43A	Bolt	30 Ea (2 ea)	100-Start up Operation	5062284
MS21044N4	Nut, Self-Locking	15 Ea (1 ea)	100-Start up Operation	5092510X12
MS21044N5	Nut	30 Ea (2 ea)	100-Start up Operation	511266
MS24665-132	Cotter Pins	15 Ea (1 ea)	100-Start up Operation	5097089
NAS1149C0463R	Washer	60 Ea (4 ea)	100-Start up Operation	51136349-40
NAS1149C0563R	Washer	60 Ea (4 ea)	100-Start up Operation	5053953
				5060989

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Start up Operation	644.4103	15	0	0
	644.4110	15	0	0
	644.4112	30	0	0
	644.4113	30	0	0
	644.4118	30	0	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss ☐ Folio/Prog ☐ Grain ☐ Weld ☐ Wrong Stc ☐ Out of Sec ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐			
		OTHER : ☐			

Inspector
 Date: 10/23/10
 Part: 644.4101
 Job No: 181912
 Serial No/Batch: S120734
 Revision: F2
 Inspector:
 Exp Date:
 Instructions:

DART
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Dart Aerospace Ltd.
 Engineering
 Design
 Production
 Quality
 Sales
 Marketing
 Purchasing
 Human Resources
 Finance
 Information Systems
 Maintenance
 Safety
 Environmental
 Compliance

644.4120	15	0	0
AN310-4	15	155	0
AN4-45	15	16	0
AN4-47A	15	29	0
AN5-43A	30	44	0
MS21044N4	15	128	0
MS21044N5	30	319	0
MS24665-132	15	271	0
NAS1149C0463R	60	171	0
NAS1149C0563R	60	388	0

Part Specifications

Specifications could not be found.

Plex 8/13/18 1:28 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					